

Date: Thursday, 4/12/2007 8:46:19 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31733	
Estimate Number : 11479	
P.O. Number	Part Number : D31451
This Issue : 4/12/2007 S.O. No. :	Drawing Number : D3145 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 26502	Material
Written By	Due Date : 5/10/2007 Qty: 6 Um: Each
Checked & Approved By : <u>4/07/04.12</u>	
Comment : Est. A 03.02.28 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X02000	6061-T6 Bar 2.0" x 2.0"
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Comment: Qty.: 0.4025 f(s)/Unit Total: 2.4148 f(s)
6061-T6 Bar 2.0" x 2.0"
Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8)
M6061T6B2.000x2.000
Batch: M/6724

J.L 08/06/24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

J.L 08/06/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine per Folio FA318 and Dwg D3145
Deburr and Tumble

PTO
2/ 08/07/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2/ 08/07/03 (6)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

RQ 08/07/04 (6)

INFORMATION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3145-1 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/07/11
A412-694-013 QA: N/C Closed: A Date: 08/07/11

NCR: 31733		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/04	3.0	Scrap parts #3 and #4 Because they ^{move} move in the jig and the tolerance of .219 IS under.	08.07.04	Place skin in front and Behind pit bull clamp	08/07/04	08/07/04	08.07.04	08/07/04
		PC use skin + Pit bull clamp was not tight enough		Scrap and Destroy and Replacer B# <u>16724</u>		08/07/04		08/07/04

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31733

Part Number: D31451

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-07-07

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YL 08-07-07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-07

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *68*

8/7/9

xc

sc

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10

Job Completion



MF 08-07-10

07/07/2008
S.033 13.08
#1 319.5 F
#2 F
#3 F
#4 F
D31451
331733
30mins

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31733
Description: Bracket		Part Number:	D3145-1
Inspection Dwg: D3145 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	+/-0.010	.233				
0.180	+/-0.010	.180				
R0.250	+/-0.010	.250				
1.250	+/-0.010	1.249				
1.960	+/-0.010	1.958				
Ø0.221 x 0.351	+/-0.010	.228 x .352				
0.108	+/-0.010	.118				
0.125	+/-0.010	.125				
1.636	+/-0.010	1.628				
R0.188	+/-0.010	.188				
0.125	+/-0.010	.122				
95°	+/-0.5°	95°				
R0.387	+/-0.010	.387				
0.766	+/-0.010	.766				
0.250	+/-0.010	.255				
1.370	+/-0.010	1.375				
0.760	+/-0.010	.760				
4.303	+/-0.010	4.305				
0.219	+/-0.010	.212				

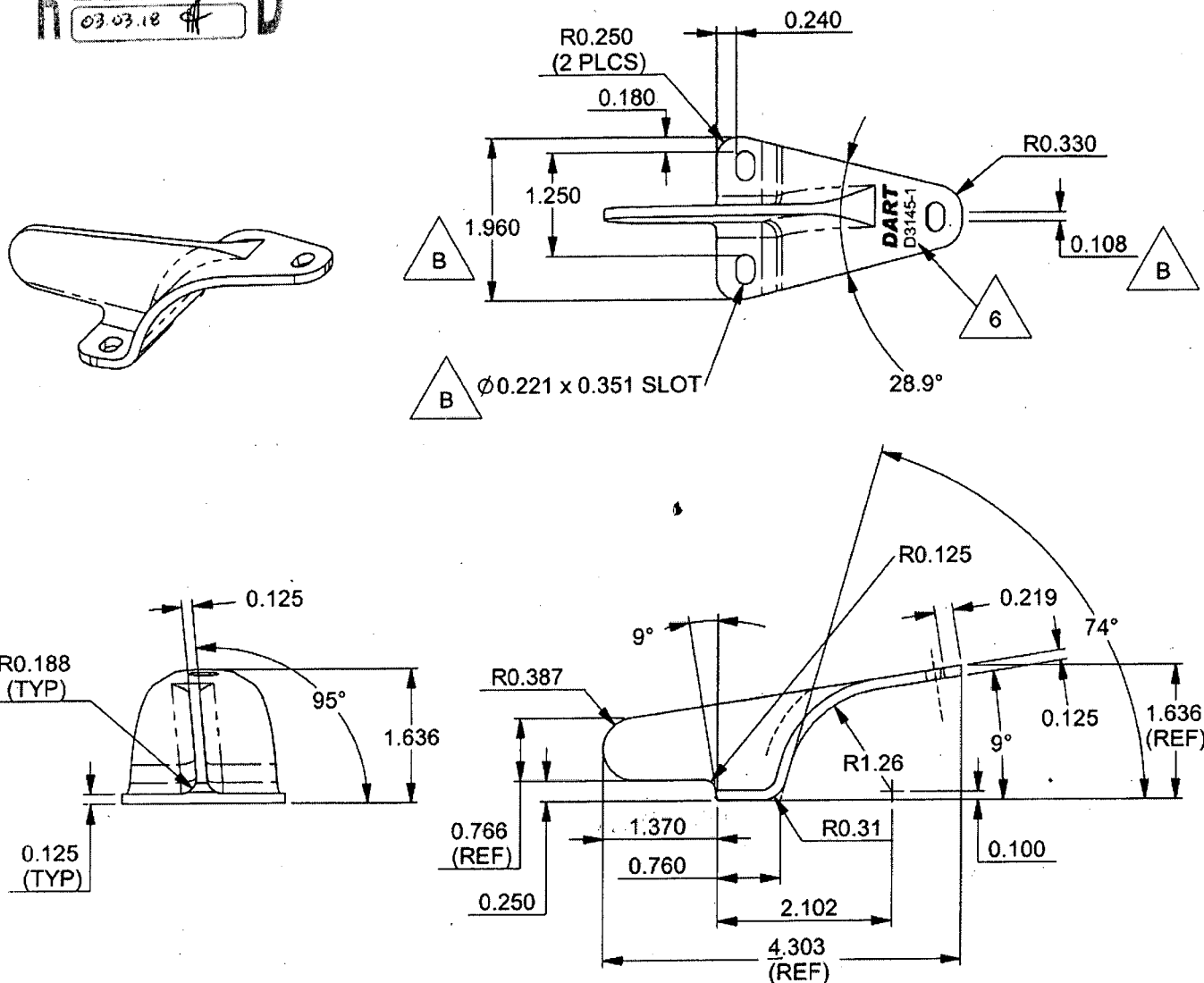
Measured by:	J.L.K.	Audited by:	J.B.	Prototype Approval:	N/A
Date:	08/07/03	Date:	208/02/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED
03.03.18



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31733

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